

Work Order ID 57753

April 14, 2010 11:38:45 AM



Page 1

Item ID: ~D3163-3

Accept



Setup Start



Revision ID:

Item Name: Plate

Stop



Start Date: 4/14/10

Start Qty: 4.00



Cust Item ID:

Required Date: 4/19/10

Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

W

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3163

Rev E

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3163

Dwg Rev: *E*

Prog Rev: *E*

2-Deburr if necessary

B 10-6-3

B

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B 10-6-3

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

S 10-6-6-3

(X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10.06.22	30	C.S. $\phi 0.098$ HOLES $\phi 0.179 \times 100^\circ$				CP 10.06.22 GSI	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 57753

April 14, 2010 11:38:45 AM



Page 2

Item ID: D3163-3

Accept



Setup Start



Revision ID:

Item Name: Plate

Stop



Start Date: 4/14/10

Start Qty: 4.00



Cust Item ID:

Required Date: 4/19/10

Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Small Fab

Small Fab

0.00

Memo

0.00

Small Fab

1- c/sink holes as per dwg
2- deburr

EP 10/06/23 (5)

140



HandFinish

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

Hand Finishing

MA 10 06 24 (5)

150



QC

QC3- Inspect Part Finish

0.00

Memo

0.00

Quality Control

(5) BR 10-6-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 57753

April 14, 2010 11:38:46 AM



Page 3

Item ID: D3163-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Plate

Start Date: 4/14/10

Start Qty: 4.00



Cust Item ID:

Required Date: 4/19/10

Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

Identify as per dwg & Stock Location: 178

0.00



Packaging

Memo

0.00

Packaging

10-6-25

(5x)

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/06/28

CZ 10/06/25

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April 14, 2010 11:38:44 AM

Page 1

Work Order ID: 57753



Parent Item: D3163-3



Parent Item Name: Plate

Start Date: 4/14/10

Required Date: 4/19/10

Comments: IPP B05.10.25 Remove Powder Coat KJ/RF
IPP C06.06.06 Waterjet EC

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M2024T3S.032		Purchased	No			100	sf	139.0000	1.3558			



2024-T3 .032 sheet



1810-6-3

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT22

139

105555

3

110778

4

111699

4

113189

128

113189

5

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

D3065-5DART AEROSPACE LTD		Work Order:	SPFS3
Description: Plate		Part Number:	D3163-3
Inspection Dwg: D3163	Rev: <i>0</i>		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

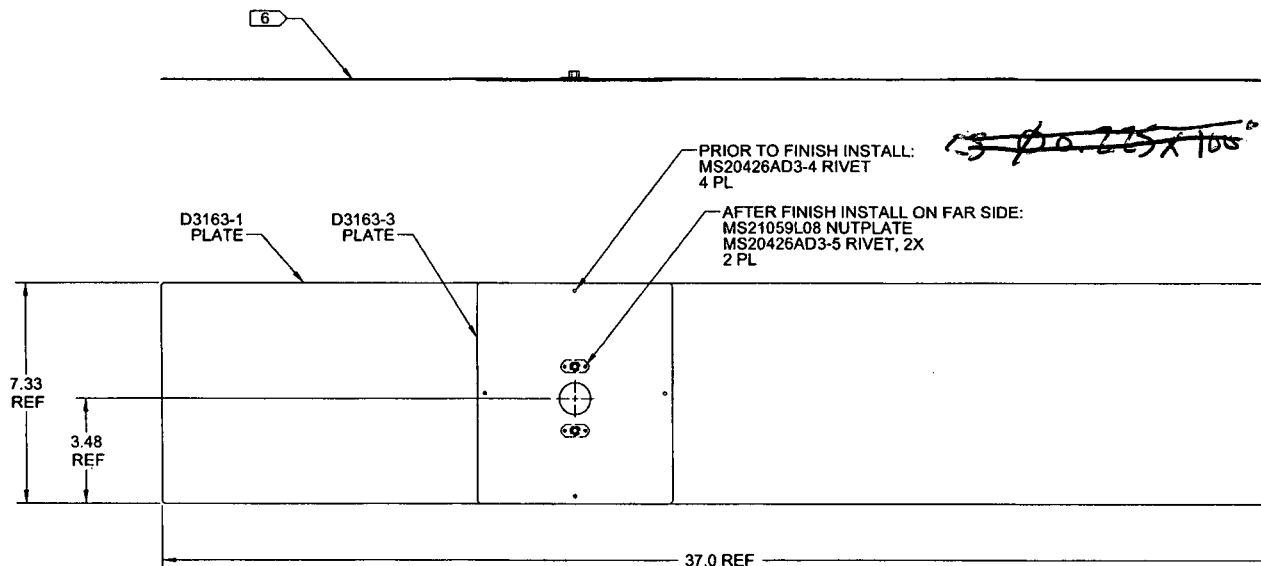
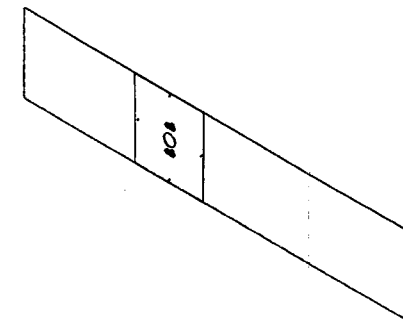
☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.004/-0.001	.099	✓			
Ø0.250	+0.005/-0.001	.252	✓			
Ø1.050	+0.012/-0.001	1.052	✓			
3.663	+/-0.010	N/A	✓			<i>10.06.03</i>
3.483 ✓	+/-0.010	3.481	✓			
1.063 ✓	+/-0.010	1.064	✓			
3.250 ✓	+/-0.010	3.250	✓			
6.50 ✓	+/-0.030	6.508	✓			
0.344 ✓	+/-0.010	.343	✓			
0.250 ✓	+/-0.010	.251	✓			
7.33 ✓	+/-0.030	7.357	✓			
<i>0.032"</i> 0.063	+/-0.010	.032	✓			

Measured by: <i>HB</i>	Audited by: <i>8</i>	Prototype Approval:	N/A
Date: <i>10-6-03</i>	Date: <i>10/06/03</i>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.10.16	New	KJ <i>[Signature]</i>	<i>[Signature]</i>

ITEM	QTY	P/N	DESCRIPTION
1	X	D3163-041	PLATE
2	1	D3163-1	PLATE
3	1	D3163-3	PLATE
4	4	MS20426AD3-4	RIVET
5	4	MS20426AD3-5	RIVET
6	2	MS21059L08	NUTPLATE



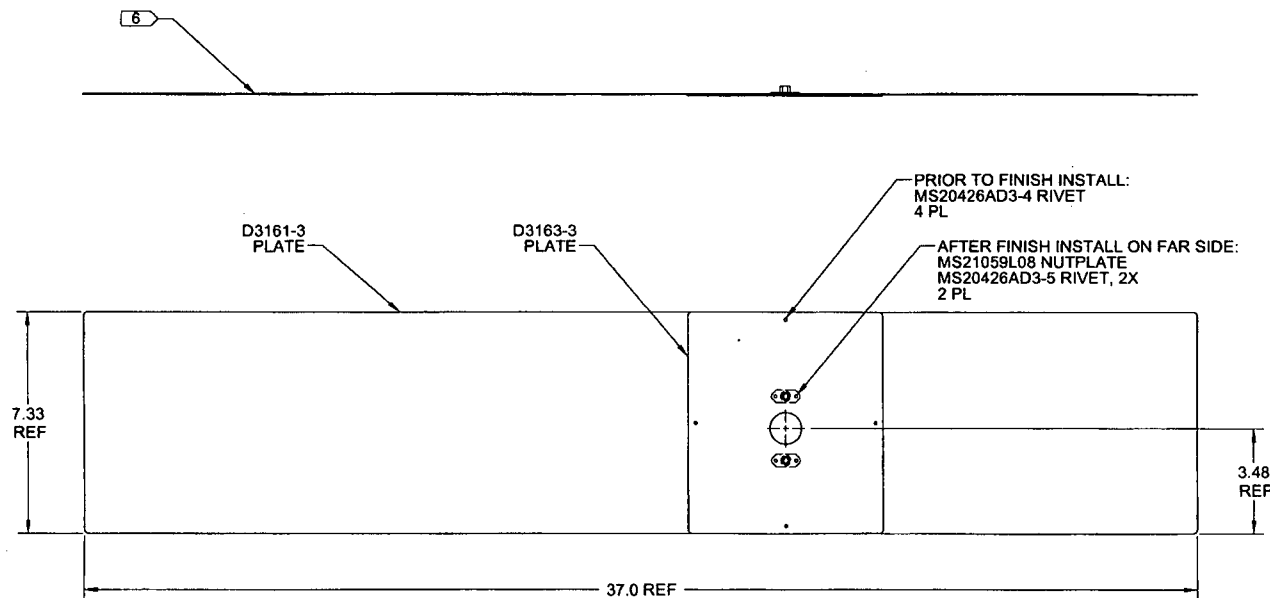
D3163-041 PLATE

RELEASED
2009-11-09
mp

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT GREY SANDEX (4.3.5.6) PER DART QSI 005 4.3 AFTER ASSEMBLY OF D3163-3 PLATE PRIOR TO INSTALLATION OF MS21059L08 NUTPLATES
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3163-041" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 1.00 lbs

E	REDRAW, 13.69 WAS 12.81 (TYPO, ZN B6-3), INCR 09-095	CP	09.10.21
D	ADD 4 RIVETS, RMV ADHESIVE	CB	06.06.26
C	Ø 1.050 WAS Ø 1.000	RF	05.11.22
B	7.33 WAS 7.20, RMV PERIMETER HOLES	RF	04.10.06
A	NEW ISSUE	RF	02.04.26
REV.	DESCRIPTION	BY	DATE
DESIGN	DRAWN	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3163 TITLE PLATE SCALE NTS	
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.10.21	<small>COPYRIGHT © 2002 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

ITEM	QTY	P/N	DESCRIPTION
1	X	D3163-042	PLATE
2	1	D3163-1	PLATE
3	1	D3163-3	PLATE
4	4	MS20426AD3-4	RIVET
5	4	MS20426AD3-5	RIVET
6	2	MS21059L08	NUTPLATE



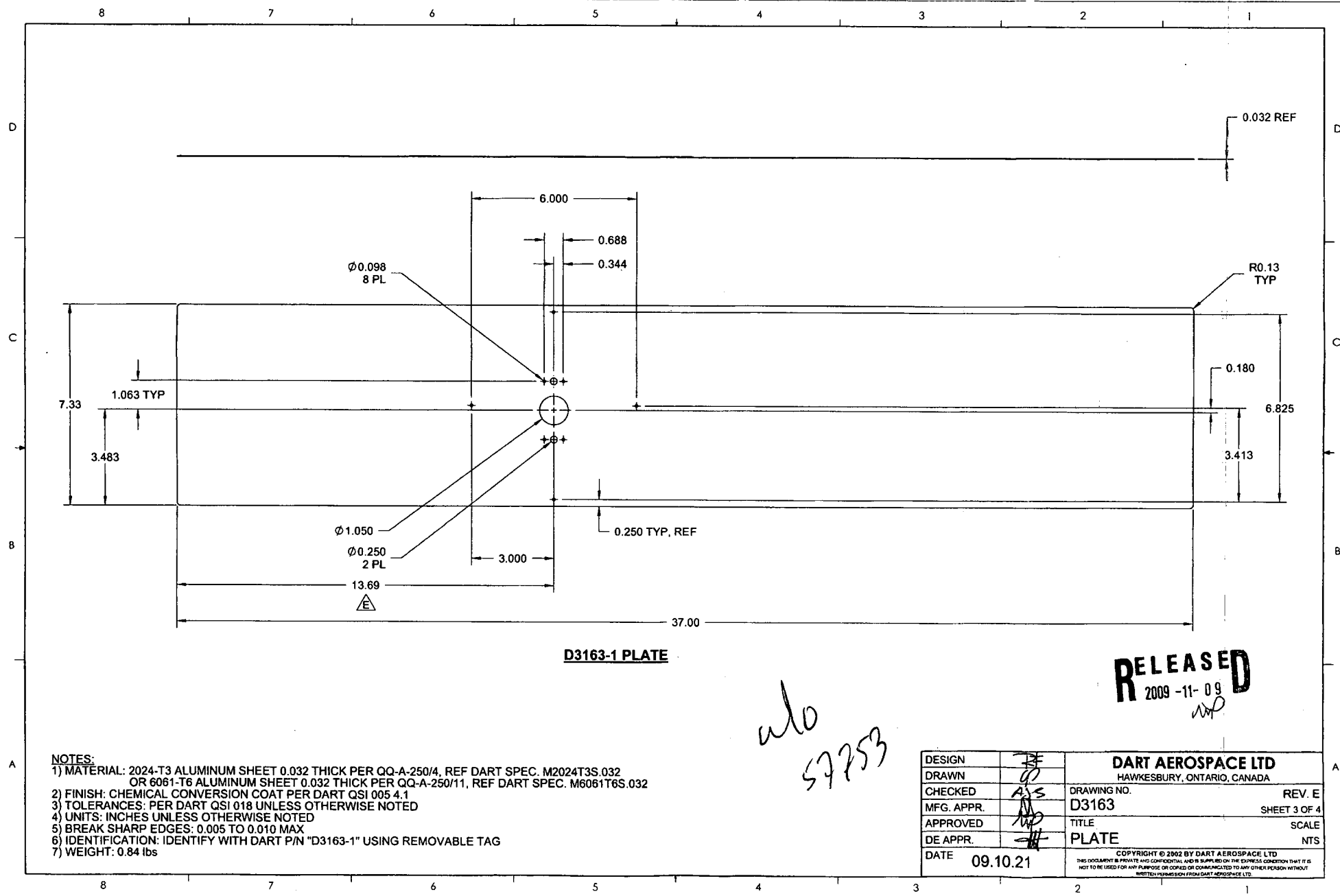
D3163-042 PLATE

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3 AFTER ASSEMBLY OF D3163-3 PLATE
PRIOR TO INSTALLATION OF MS21059L08 NUTPLATES
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3163-042" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 1.00 lbs

DESIGN	2	DART AEROSPACE LTD	
DRAWN	10	HAWKESBURY, ONTARIO, CANADA	
CHECKED	25	DRAWING NO.	REV. E
MFG. APPR.	10	D3163	SHEET 2 OF 4
APPROVED	10	TITLE	SCALE
DE APPR.	10	PLATE	NTS
DATE	09.10.21	COPYRIGHT © 2002 BY DART AEROSPACE LTD	
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RELEASED
2009-11-09



D3163-1 PLATE

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.032 THICK PER QQ-A-250/4, REF DART SPEC. M2024T3S.032
OR 6061-T6 ALUMINUM SHEET 0.032 THICK PER QQ-A-250/11, REF DART SPEC. M6061T6S.032
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3163-1" USING REMOVABLE TAG
- 7) WEIGHT: 0.84 lbs

*who
57753*

RELEASED
2009-11-09
mp

DESIGN	<i>JE</i>	DART AEROSPACE LTD	
DRAWN	<i>AS</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>AS</i>	DRAWING NO.	REV. E
MFG. APPR.	<i>MP</i>	D3163	SHEET 3 OF 4
DE APPR.	<i>MP</i>	TITLE	SCALE
DATE	09.10.21	PLATE	NTS
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